

W-Jet

4306



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM632V3023125-3

Job Sheet 181068



JL-S

8 DAS
21
9-89

8-21

Part No: RBEM632V3023125-3

Job Qty: 6 ea

Part Name: Tyhreaded Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 7/20/18

Job Tracking No:

Due Date: 8/7/18

Created By: Logan David

Type: SOLD

Description:

Note: RBEM632V3023125 rev.1 IPP REV:A 18.07.18 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	8/7/18	8/7/18	0.00	0.00	Start Up Waterjet2		18/07/24
100	Waterjet	6 pcs	8/7/18	8/7/18	0.08	0.75	Waterjet 2 OMAX		18/07/24
110	QC	6 pcs	8/7/18	8/7/18	0.00	0.00	QC2 Waterjet-4		18/07/24
120	Mill Conv	6 pcs	8/7/18	8/7/18	0.50	0.75	Mill Conv 2		18/7/30 J.C.
130	QC	6 pcs	8/7/18	8/7/18	0.00	0.00	QC2 Machining-5		18/07/31
140	QC	6 pcs	8/7/18	8/7/18	0.00	0.00	QC8 Machining-5		18-07-31
145	HandFinish	6 pcs	8/7/18	8/7/18	0.00	0.75	HandFinish7		18-07-31
150	Powdercoat	6 pcs	8/7/18	8/7/18	0.00	0.75	Powdercoat13		18-07-31
160	QC	6 pcs	8/7/18	8/7/18	0.00	0.00	QC3		18-07-31
170	Packaging	6 pcs	8/7/18	8/7/18	0.00	0.00	Packaging3-2		18-07-31
180	QC21-SA	6 Ea	8/7/18	8/7/18	0.00	0.00	QC21		18-07-31

Part Op 100 - ***EUROCOPTER FOLDER*** 1-Cut as per Dwg Dwg Rev: 1 Prog Rev: 1 2-Deburr if necessary
 Descriptions: 120 - 1- OPEN HOLES TO SIZE AND TAP HOLES 3- DEBURR
 150 - ***MASK THREADED HOLES PRIOR TO POWDERCOAT*** START TIME: 9:10 AM OVEN TEMPERATURE: 320°C FINISH TIME: 5:10 PM
 170 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-P-0.500	Hot Rolled Steel Plate 0.500" (44W)	.1980 sf (.033 ea)	90-Start up Operation	5048042

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-HRS-P-0.500	0	14	0

Part Specifications

Specifications could not be found.

Plex 7/20/18 8:11 AM dart.logan.david

DAS
13
9-89



Container No: S095472



Part: RBEM632V3023125-3

Job No: 181068

Serial No/Batch: S095472

Revision: 1

Inspector:

Exp Date:

Instructions:

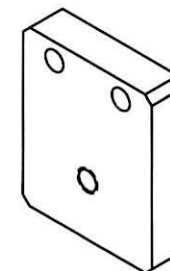
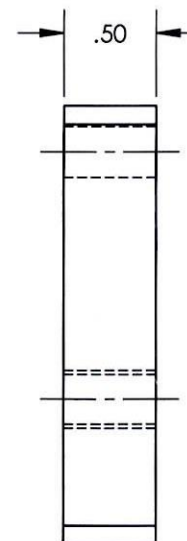
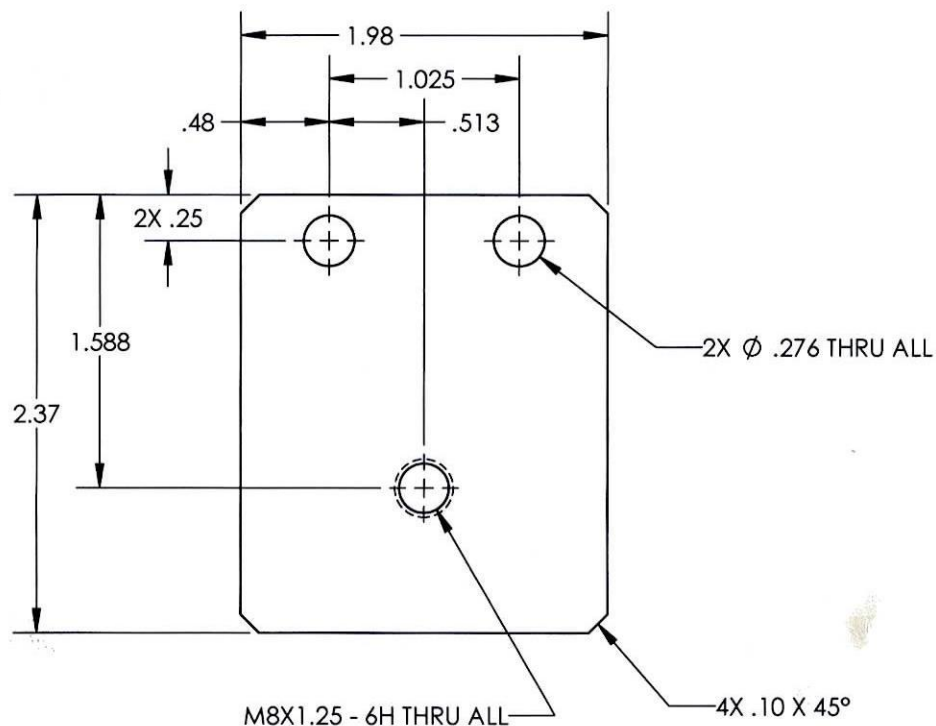
Dart Aerospace Ltd.
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/24/18

SAC
SC
28-2

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



SHOP COPY
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SUBMIT
WORK ORDER
NO. 18068

③

20180720

THREADED PLATE

DART AEROSPACE	
TITLE UPPER SERVO CONTROL AXLE EXCHANGE	
DWG NO. RBEM632V3023125-3	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/16
FINISH POWDER COAT YELLOW	.XX ± .01 ANGLES ± .5°
SPEC FED #13538	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 3/24/2016 SHEET 3 OF 6

181068

Page 1 of 1

Vernier JWS
"
Tap & Bolt

18/07/24

Date:

Revised by	Approved
KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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